

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007164**Date Inspected:** 12-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Test Coupon**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

WELDING LAB

This QA Inspector observed Submerged Arc Welding (SAW) of a Complete Joint Penetration (CJP) single V groove butt joint for Procedure Qualification Record (PQR) #HP2009300. The PQR is splicing ASTM A709 Grade HPS485WT2 (heat # 07104044N) material to ASTM A709 Grade 345T2 (heat # 07102307N) material. The 700mm (L) x 90mm (T) test coupon was being welded in the 1G (flat) position with steel backing. The electrode was classified as H14, 4.8mm in diameter with S-737 flux. The Welder was identified as Jing Rong. This QA Inspector observed weld passes 25 thru 69. Welding of the PQR will continue on 5-13-09. ABF representative Craig Knopps was present during the welding of the PQR. Welding of the PQR began on 5-11-09; weld passes 1 thru 24 were deposited and observed by QA Inspector Charlie Franco.

ZPMC Quality Control (QC) Inspector is identified as Huang Wei and was observed monitoring welding parameters and recording information in PQR log.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
